

## **ABSTRACT**

Stable water-borne polymer compositions are disclosed. The compositions comprise a water-borne polymer, a metal cross-linking agent and a stabilizing agent comprising from 2 to 10 carbon atoms and at least two functional groups independently selected from hydroxy and carboxy. The stabilizing agent is present at 1.4 mole percent or more of the amount of metal cross-linking agent. Inventive compositions are particularly suitable for use in water-based inks and coatings. Methods of making and using the coating compositions are also described.